

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013110**Date Inspected:** 18-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 7DW

ABF Request No. 04182010-1

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Rejectable indications were observed. Inspection was carried out on repair areas. Weld identification numbers were.

CA043-004 (7EW- DP to EP, CB side)

CA044-004 (7EW- DP to EP, CW side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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planar transverse indication. For more information refer the ABF /CT report dated on 04/18/2010.

### ULTRASONIC INSPECTION

#### OBG SEGMENT 7BW-7CW

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of OBG components previously accepted by ZPMC ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3 and Detection of Transverse Planar Discontinuities with Significant Flaw Height Dimension Procedure. Inspection was carried out on repair areas. Weld identification numbers were.

OBW7-010 (7BW-7CW- EP to EP, CB side)

This QA Inspector performed conventional UT (Ultrasonic Testing) after ABF UT department for detection of planar transverse indication.

No relevant indication observed.

### MAGNETIC PARTICLE INSPECTION

#### OBG SEGMENT 7BW-7CW

This QA Inspector Witnessed ABF personal performing Magnetic particle Testing (MT) on weld between edge panel and edge panel (cross beam side) between the OBG segment 7BW-7CW. Weld identification number was.

OBW7-010 (7BW-7CW- EP to EP, CB side)

This QA Inspector randomly observed the following work in progress.

#### OBG SEGMENT 8CE

This Quality Assurance (QA) Inspector observed ZPMC QA Inspector performing magnetic particle inspection on the gouged areas of the weld between deck panel and edge panel (bike path side).

#### OBG SEGMENT 7DE-7CE

This Quality Assurance (QA) Inspector observed ABF QA Inspector performing Ultrasonic inspection for the deck panel splice weld between OBG segment 7DE and 7CE.

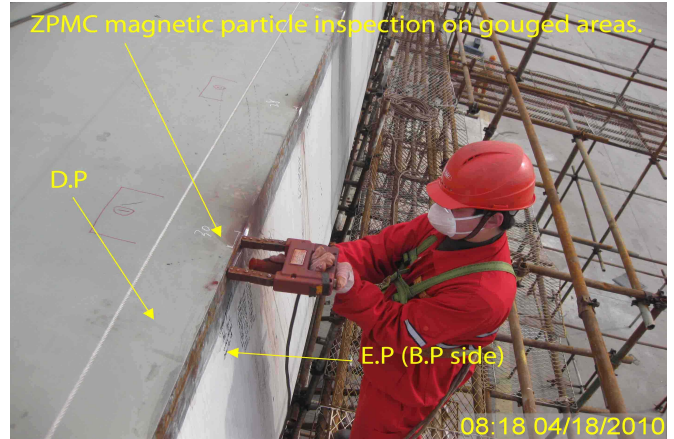
Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer